

8

Date: Wednesday, 2/6/2008 10:25:22 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASSEMBLY
Job Number : 37247B	
Estimate Number : 10207	
P.O. Number :	Part Number : D2989043
This Issue : 2/6/2008 S.O. No. :	Drawing Number : D2989 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 37094B	Material :
Written By :	Due Date : 2/18/2008 Qty: 1 Um: Each
Checked & Approved By : <u>LA 080206</u>	
Comment : Est Rev:1 Removed D2989-041 05-11-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number	Description	Batch
2 D3182-1	Hinge	336483 ✓

FC 08 04 25

2.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number	Description	Batch
2 D3442-3	Shim	326740 ✓

FC 08 04 25

3.0	M304EX07516F	Expanded Metal Flat Stai
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Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)

Pick:

Qty Part number	Description	Batch
8sf M304EX0.75-16F Expanded Metal		M107316 ✓

FC 08 04 25

4.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.065" wall 304/316 SS tubing.

Batch: M107515 ✓

FC 08 04 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/6/2008 10:25:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 37247B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

FL

2-Drill holes in tubing as D2989-043 per Dwg D2989

FL

3-Deburr and remove all markings on material

FL

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

PD 08-04-28
FL 08-04-25

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-28

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 08-04-28

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

M107550

08-04-28

137247B
D2989043
28/04/2008
S.129 12.9
#1 401.5
#2 30min
#3 ---
#4 ---

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

08/04/28

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28

Job Completion



MF 08-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05-08-19 *[Signature]*

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

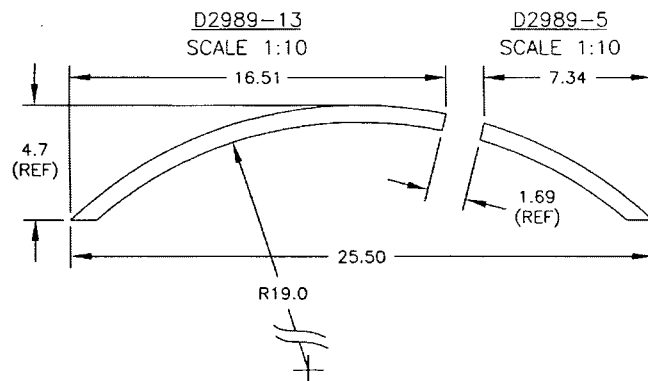
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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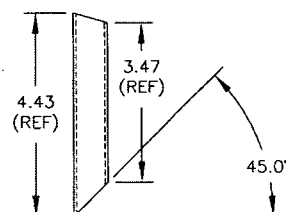
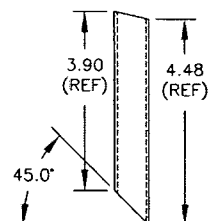
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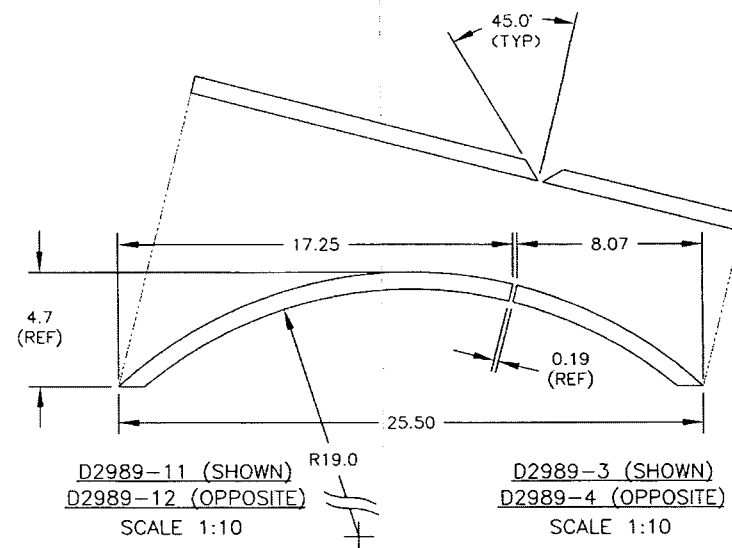
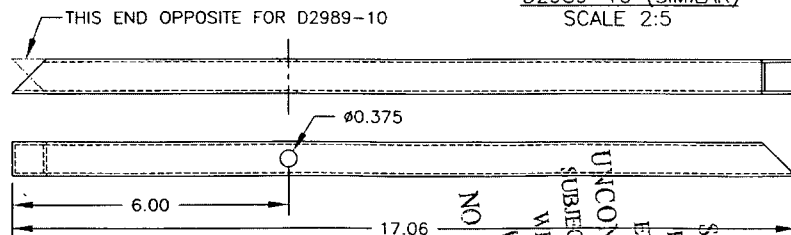


D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

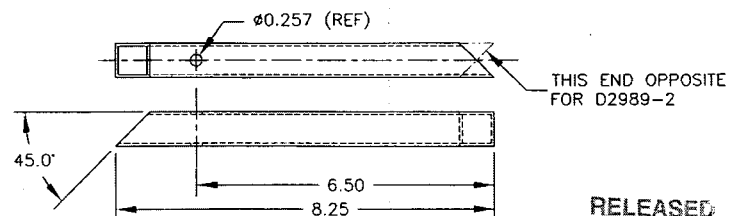
D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5



D2989-1 (SHOWN)
D2989-2 (OPPOSITE)
SCALE 2:5



RELEASED

05-08-19

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DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
DATE	05.06.07	TITLE	BASKET LID ASSEMBLY	D2989	SHEET 3 OF 3
		SCALE	1:10		

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